

Work Order ID 65516

January 19, 2011 11:31:18 AM



Page 1

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2574	Rev E
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100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. _____ Double check by: SA 11/2/7/SL
□1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-
Machine Step No 3 per Folio FA051 and insp

10

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10

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Page 2

Item ID: D2574

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft In 205

Stop



Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

enr 11/02/08

10

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10

BL 11-029

Hand Finishing

150

~~White Gloss~~(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

A POWDER COAT DRAB GREEN

PER QSI 005

START TIME:

11:00 FINISH TIME:

320 OF

OVEN TEMPERATURE:

11:30

(10x)

m-1 11/03/01

M1 04476

Work Order ID 65516

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Page 3

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 p 11/03/01

170

Identify as per dwg & Stock Location: 423

0.00



Packaging

Memo

0.00

Packaging

11/2/12 102

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/03

11-03-2
10

Picklist Print

January 19, 2011 11:31:10 AM

Page 1

Work Order ID: 65516

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205



Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-005

Manufactured

No

110

Each

17.0000

1

10



Saddle Billet



11/3/7

Location

Loc Qty

Loc Code

MAT46

17

46411

1

62394

16

65382

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 65516
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.442	.438	.438	.438	Verh	SL-3
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001	Verh	CNC-02
F	0.490	0.510		.500	.499	.501	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.502	.502	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.126	.126	mic	118-120
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.130	.127	.126	mic	118-120
T	0.178	0.198		.188	.188	.188	.188	R-G	
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.237	.238	.236	.237		
W	0.115	0.135		.128	.127	.128	.129	mic	118-120
X	0.307	0.312		.311	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.361	.361	.361		
AA	0.470	0.530		.500	.500	.500	.500	R-G	
AB	0.615	0.635		.626	.626	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.244	.248	.247		
AE	1.500	1.520		1.517	1.516	1.516	1.516		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.245	.246	.246	.248		
AI	2.000	2.020		2.007	2.006	2.006	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SL
Date: 11/02/01

Audited by: Gmf
Date: 11/02/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 65516
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.38	.838	.838	.838		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.502	.503	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.570	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.238	.238	.238	.238		
W	0.115	0.135		.130	.129	.129	.129		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.246	.247	.248		
AE	1.500	1.520		1.515	1.515	1.515	1.515		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.248	.247	.248		
AI	2.000	2.020		2.005	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	11/11/02

Audited by:	AME
Date:	11/12/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD	Work Order:	65516
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.002				
F	0.490	0.510		.502	.501				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.502	.501				
J	1.174	1.184		1.179	1.175				
K	0.558	0.578		.569	.569				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.126	.127				
Q	0.115	0.135		.136	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.127	.127				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.238	.238				
W	0.115	0.135		.127	.127				
X	0.307	0.312		.309	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.361	.361				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.626	.626				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.245	.244				
AE	1.500	1.520		1.517	1.518				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.245	.246				
AI	2.000	2.020		2.008	2.008				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

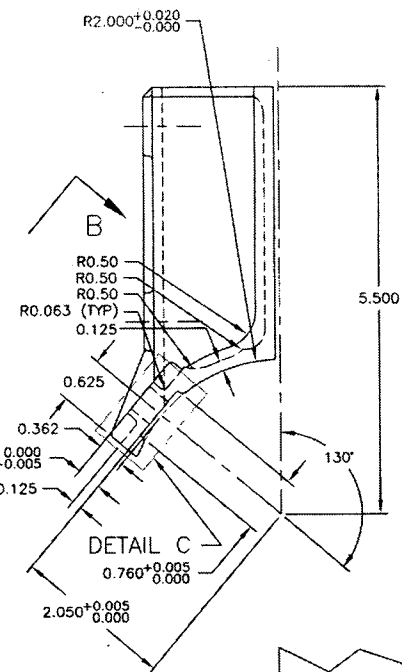
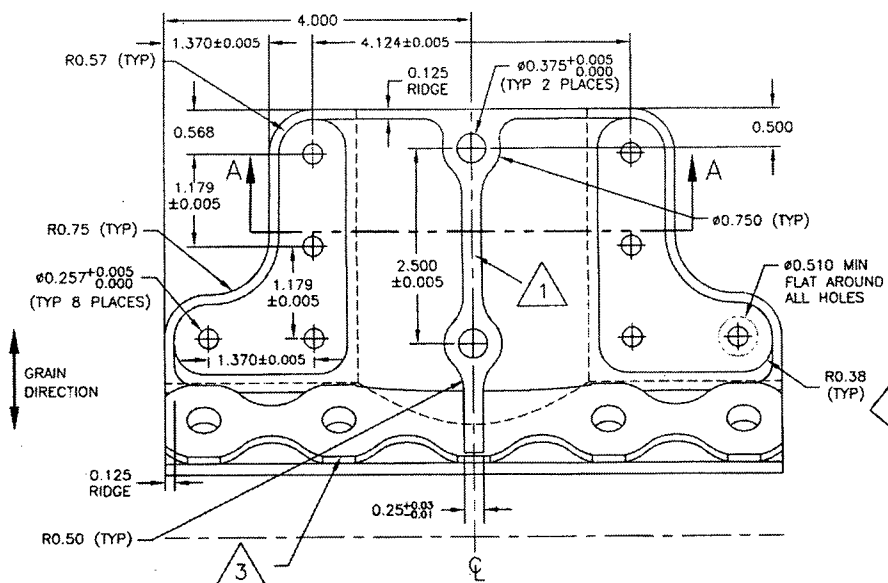
Measured by:	SA
Date:	11/2/17

Audited by:	ml
Date:	11/02/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

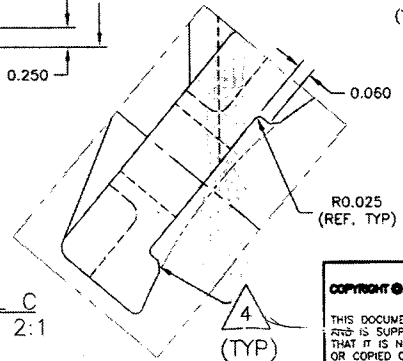
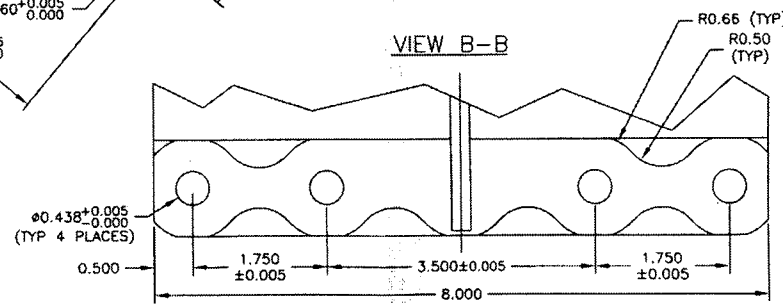
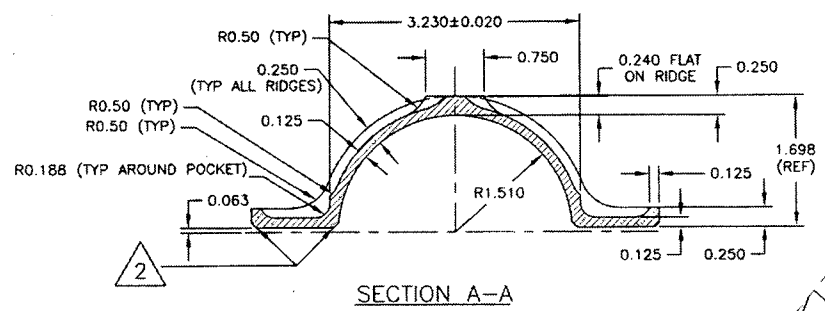
05.12.06



NOTES

MATERIAL: 7075-T7351 (00-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



SECTION A-A

VIEW B-B

DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	✓	APPROVED
DATE	05.07.13	TITLE INNER AFT SADDLE
DRAWING NO.	02574	REV. E
		SHEET 1 OF 1
		SCALE 2:3

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10 65516